

Date: Wednesday, 07/01/2009 1:36:50 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: STA 155 BRACKET		
<b>Job Number</b>	: 44475			<b>Part Number</b>	: D28041		
<b>Estimate Number</b>	: 11039			<b>Drawing Number</b>	: D2804 REV C		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 07/01/2009	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: C		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: SMALL /MED FAB	<b>Due Date</b>	: 23/01/2009	<b>Qty:</b>	8
<b>Previous Run</b>	: 41739			<b>Um:</b>	Each		
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>JUL 09. 01.09</u>						
<b>Comment</b>	: Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC Est Rev:C As per Rev C 06-11-09 JLM Est Rev:D Removed Tumbling 08-09-09 JLM Verified By:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X12000	6061-T6 Bar .500 x 12.00	
		Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50"	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> <u>IB 9-1-12</u>	
		2-Deburr if necessary	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2804-1 PAR #: N/A Fault Category: Prod/PAB Ass med \* 500011 NCR: Yes No DQA: D Date: 09/01/13  
 D2804-0917043 D412-630-013/023/033/011 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/01/13

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/13	3.0	TOP .757 "Hole is .764"  R.C changed P/N but forgot to change offset.	CP 09.01.13 PV QSLUVR	SCRAP PART. ENG IS UNABLE TO SUBSTANTIATE DEVIATION ON HOLE AS PART WAS SUBST. BY TEST.	MNU 09/01/13	CP 09/01/13	CP 09.01.13 PSI 042	G 09/01/13
		Human error Lack of Attention. Worker Set.		and replace qty (X) B/E 109253				

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 44475

Part Number: D28041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*mk 09/01/17*

(8)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*ff*

*09-01-20*

(X)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 151A

*SS*

*09/01/20 (X)*

8.0 QC21 FINAL INSPECTION/W/O RELEASE



*09/01/20 (X)*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 09/01/20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	W4475
Description: Bracket	Part Number:	D2804-1
Inspection Dwg: D2804	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

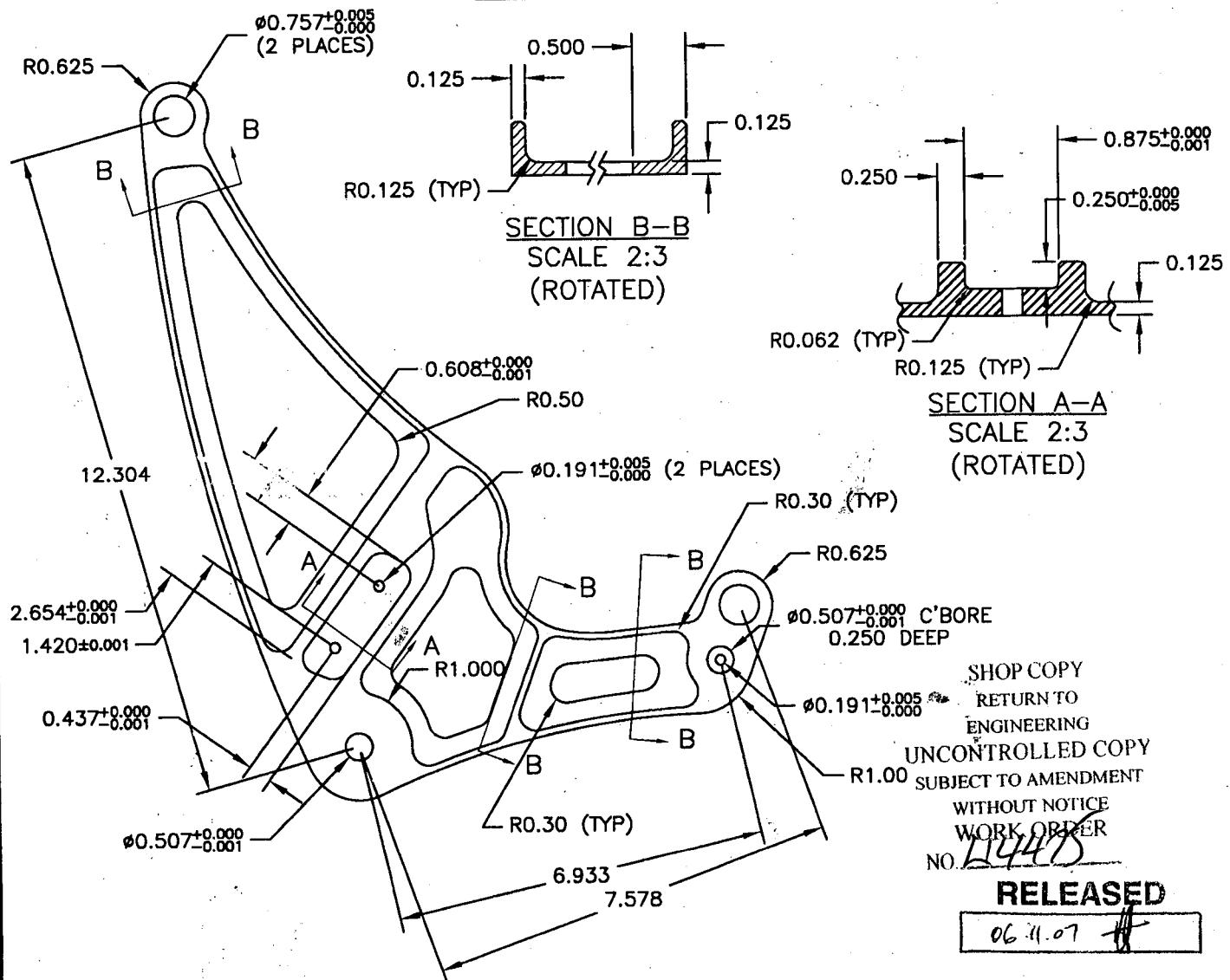
X First Article | Prototype

Measured by:	<i>mmt</i>	Audited by:	<i>mg</i>	Prototype Approval:	N/A
Date:	09/01/13	Date:	09/01/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	E

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <del>H</del>	APPROVED <del>H</del>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

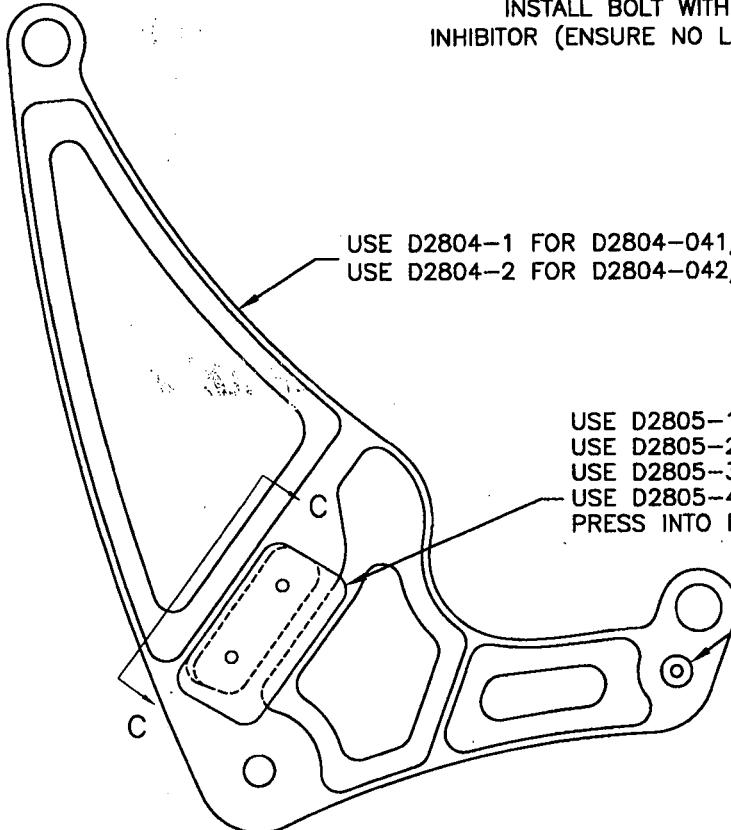
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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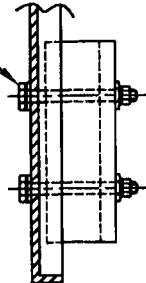
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21042-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



USE D2804-1 FOR D2804-041/-043  
USE D2804-2 FOR D2804-042/-044

SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2805-1 FOR D2804-041  
USE D2805-2 FOR D2804-042  
USE D2805-3 FOR D2804-043  
USE D2805-4 FOR D2804-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO  
POWDER COAT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *44475*

**RELEASED**

06.11.07 *[initials]*

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**

**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3